

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006888**Date Inspected:** 19-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress: FCAW welding of weld joint 047 located on Floor beam FB003-167. ZPMC welder was identified as 048714. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 093 located on Floor beam FB007-010. ZPMC welder was identified as 207465. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

Bay 7-

This QA Inspector observed the following work in progress: SMAW tack welding of weld joints 001, 002, 003 and 004 located on Side Plate SP205-013. ZPMC welder was identified as 203204. ZPMC QC is identified as Xu Xian Ping. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2112.

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This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations after weld repair. Testing was performed in accordance with Caltrans UT procedure “ Phased Array Testing” for detection of planar discontinuities (cracks) in PJP welds. Results of Deck Panels evaluated are as follows:

DP477-001 (9EE): 45 locations tested with 4 rejected (R1).

This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations. Caltrans NDT personnel performed conventional ultrasonic testing of tack welds. Tack weld locations that exhibited crack like indications in the area of interest were marked and recorded prior to PAUT. PAUT was performed in accordance with Caltrans UT procedure “ Phased Array Testing” for detection of planar discontinuities (cracks) in PJP welds. Results of Deck Panels evaluated are as follows:

DP284-001 (9AW) 12 locations tested with 8 locations rejected.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
